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審査請求　未請求　請求項の数１　ＯＬ　（全３頁）

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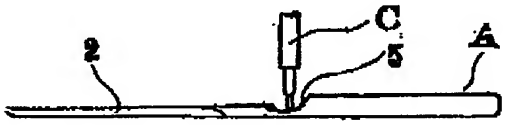
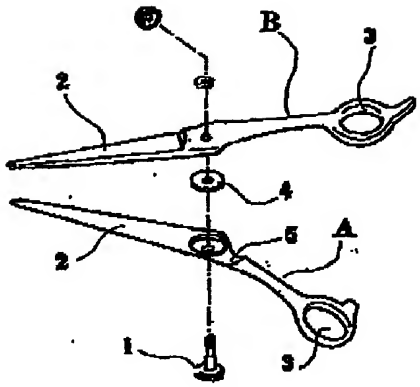
(54)【発明の名称】　理容鋏の製造方法

(57)【要約】　（修正有）
【課題】理容鋏の逃がし凹部の仕上げ加工をエンドミル加工で行うもので、逃がし凹部の位置並びに形状が特定の形状に限定されることなくエンドミル工具を備えたフライス機械による機械処理で精密仕上げを行うことができ理容鋏製造作業の効率化を実現した。
【解決手段】鋏本体Ａ，Ｂは所定の形状に鍛造形成し、その後表面全体の研磨や刃付けを行うが、特にエンドミル工具Ｃを備えたフライス加工機械にて鋏本体Ａ，Ｂをセットして、工具Ｃにて表面を切削することで表面仕上げを行うものであり、研磨と同様の切削による精密仕上げを行うことができる。

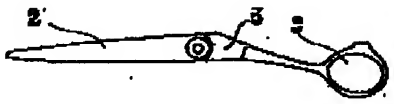


【特許請求の範囲】
【請求項１】　先部に設けた刃体と基部に設けた把持部とを備えた鉄本体を交叉重合し、交叉部分を枢結軸で枢結すると共に、枢結軸の基部側の内摺面外周の逃がし凹部を備えた理容鋏の製造工程に於いて、逃がし凹部の仕上げ加工を、エンドミル加工で行ってなることを特徴とする理容鋏の製造方法。
【発明の詳細な説明】
【０００１】
【産業上の利用分野】本発明は、理容鋏に於ける刃体部分と把持部分との間に形成されている内摺面外周の逃がし凹部の形状の切削加工に関するものである。
【０００２】
【従来の技術及び発明が解決しようとする課題】理容鋏は、周知の通り一方に刃体を形成し、他方に指孔を有する把持部を形成した本体を、一対交叉重合し、交叉部分を枢結してなるものである。前記の理容鋏は、切断刃先が所定の圧力をもって摺動するように、刃体に捻じりが形成されており、而も刃体の回動によって前記の捻じりは刀体の弾性に吸収されるが、その反動力は枢結軸と、枢結軸の基部側の刀体裏面の内摺面とで受けている。即ち枢結軸の基部側の刀体裏面には内摺面が形成されている。
【０００３】また前記の内摺面の更に基部側には、一般に逃がし凹部に形成されている。これは内摺面が優れた研磨面である必要から、内摺面の研磨の邪魔にならないように凹部としている。ところで近年理容鋏では、刀体間に介在させるパッキン、座金やベアリング体自体に内摺面を形成するように、内摺面が枢結軸に非常に近い箇所に設けられている。このため内摺面の基部側の逃がし凹部も、枢結軸の近傍に形成しなければならなくなった。
【０００４】しかし逃がし凹部の形成に際して、パッキン用凹部の直近であり、しかも一側は枢結軸と同心円形状としている特異な形状で、仕上げの研磨加工が非常に面倒であり、機械加工は困難である。機械加工可能とするには相応の凹部形状に特定する必要がある（特開昭５５－６３６７３号公報、特開平６－２８５２７１号公報参照）。このため逃がし凹部の仕上げ研磨は全て手作業となるため、非常に作業効率が悪い。
【０００５】そこで本発明は、逃がし凹部の新規な仕上げ加工手段を提案したものである。
【０００６】
【課題を解決するための手段】本発明に係る理容鋏の製造方法は、枢結軸の基部側の内摺面外周の逃がし凹部の仕上げ加工を、エンドミル加工で行っていることを特徴とするものである。
【０００７】従って逃がし凹部の位置並びに形状が特定の形状に限定されることなく、エンドミル工具を備えたフライス機械で、研磨と同様の切削による精密仕上げを行うことができる。
【０００８】
【実施形態】次に本発明の実施形態について説明する。本発明方法の対象となる理容鋏は、基本的には従前の鋏と同様に一対の鉄本体Ａ，Ｂを交叉重合し、交叉部分を枢結軸１で枢結してなり、鉄本体Ａ，Ｂは枢結軸１より先部方を刀体２として刃を形成し、枢結軸１より基部方を指孔３等を有する把持部としているもので、特に枢結軸１の基部側近傍に内摺面（刀体の対向面か或いは刀体対向面に介装したパッキン４自体の外周側表裏面）を備え、内摺面外周に逃がし凹部５を備えているものである。
【０００９】鉄本体Ａ，Ｂは、所定の形状に鍛造形成し、その後表面全体の研磨や刃付けを行うと共に、逃がし凹部５の研磨の仕上げを行うものであるが、特にエンドミル工具Ｃを備えたフライス加工機械に鉄本体Ａ，Ｂをセットして、同工具Ｃで表面を切削することで表面仕上げを行うものである。
【００１０】従って逃がし凹部５がどのような位置に、どのような形状で形成するにしても、その表面仕上げを機械加工処理で行うことができるものである。
【００１１】
【発明の効果】本発明は以上のとおり、理容鋏の逃がし凹部の仕上げ加工を、エンドミル加工で行うもので、逃がし凹部の位置並びに形状が特定の形状に限定されることなく、エンドミル工具を備えたフライス機械による機械処理で精密仕上げを行うことができ、理容鋏製造作業の効率化を実現したものである。
【図面の簡単な説明】
【図１】本発明方法の実施形態の対象例の理容鋏の分解斜視図
【図２】同平面図
【図３】同逃がし凹部の加工説明図。
【符号の説明】
１　枢結軸
２　刀体
３　指孔
４　パッキン
５　逃がし凹部

【図1】



【図2】



【図3】

PATENT ABSTRACTS OF JAPAN

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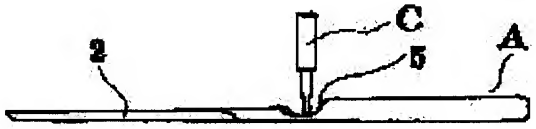
(71)Applicant : SHIGERU KOGYO:KK
(72)Inventor : FUJITA SHIGERU

(54) MANUFACTURING METHOD FOR HAIRDRESSING SCISSORS

(57)Abstract:
PROBLEM TO BE SOLVED: To improve the efficiency of the manufacturing work of hairdressing scissors by using end milling in finishing a clearance recess in the hairdressing scissors and using, as precision finishing, machining with a milling machine with an end milling tool, without limiting the position and shape of the clearance recess to a specific shape.
SOLUTION: Scissor bodies A and B are forged into given shapes before overall surface polishing and sharpening. The surface finishing is specifically executed when the scissor bodies A and B are set on the milling machine with the end milling tool C that cuts the surfaces, so that the cutting can provide precision finishing along with polishing.



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[Patent number]

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* NOTICES *

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CLAIMS

[Claim(s)]
[Claim 1] The manufacture approach of the hairdressing scissors characterized by missing and coming to finish-machine a crevice by end mill processing in the production process of the hairdressing scissors which the inner sliding surface periphery by the side of the base of a pivotable-combination shaft missed, and were equipped with the crevice while carrying out the decussation polymerization of the scissors body equipped with **** prepared in the point section, and the grasping section prepared in the base and combining a part for an intersection crotched portion pivotably with a pivotable-combination shaft.

[Translation done.]

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DETAILED DESCRIPTION

[Detailed Description of the Invention]
[0001]
[Industrial Application] The inner sliding surface periphery currently formed between parts for a sword soma and the grasping parts in hairdressing scissors misses this invention, and it relates to cutting of the configuration of a crevice.
[0002]
[Description of the Prior Art] Hairdressing scissors carry out the pair decussation polymerization of the body which formed **** in well known one side, and formed in another side the grasping section which has a finger hole, and come to join a part for an intersection crotched portion togther pivotably. Torsion is formed in ****, and although the aforementioned torsion is absorbed by the elasticity of **** by rotation of ****, ** has also received the reactionary force by the pivotable-combination shaft and the inner sliding surface of the **** intrados by the side of the base of a pivotable-combination shaft, so that the cutting edge of a blade may slide on the aforementioned hairdressing scissors with a predetermined pressure. That is, the inner sliding surface is formed in the **** intrados by the side of the base of a pivotable-combination shaft.
[0003] Moreover, still more generally the aforementioned inner sliding surface misses to a base side, and it is formed in the crevice. From the need that the inner sliding surface was excellent and of being a polished surface, this is taken as the crevice so that it may not become the obstacle of polish of an inner sliding surface. By the way, with hairdressing scissors, the inner sliding surface is prepared in the part very near a pivotable-combination shaft in recent years so that an inner sliding surface may be formed in packing and the washer which are made to intervene between ****, or the bearing object itself. The base side of an inner sliding surface missed and it had to stop for this reason, also having to form a crevice near the pivotable-combination shaft.
[0004] However, it misses, and moreover 1 side is the unique configuration made into the pivotable-combination shaft and the concentric circle configuration, and machining is [polish processing of finishing is very troublesome and] on the occasion of formation of a crevice, it is the nearest to the crevice for packing, and difficult. It is necessary to specify it as a crevice configuration suitable for making machining possible (refer to JP,55-63673,A and JP,6-285271,A). For this reason, since it misses and all finishing polishes of a crevice serve as handicraft, working efficiency is very bad.
[0005] Then, this invention is missed and proposes the new finish-machining means of a crevice.
[0006]
[Means for Solving the Problem] It is characterized by for the inner sliding surface periphery by the side of the base of a pivotable-combination shaft missing the manufacture approach of the hairdressing scissors concerning this invention, and finish-machining the crevice by end mill processing.
[0007] Therefore, the milling cutter machine equipped with the end mill tool can perform precision finishing by the same cutting as polish, without missing and a configuration being limited to the location list of a crevice by the specific configuration.
[0008]
[Embodiment of the Invention] Next, the operation gestalt of this invention is explained. The hairdressing scissors set as the object of this invention approach carry out the decussation polymerization of the scissors bodies A and B of a pair like old scissors fundamentally. It comes to

join a part for an intersection crotched portion togther pivotably with the pivotable-combination shaft 1, and the scissors bodies A and B are what forms a cutting edge by making the method of the point section into **** 2 from the pivotable-combination shaft 1, and makes the method of a base the grasping section which has finger hole 3 grade from the pivotable-combination shaft 1. Especially, the base close-attendants side of the pivotable-combination shaft 1 was equipped with the inner sliding surface (or the opposed face of ****, or periphery side table rear face of packing 4 the very thing infixed in the **** opposed face), and it missed on the inner sliding surface periphery, and has the crevice 5.

[0009] Although the scissors bodies A and B are missed and finish polish of a crevice 5 while they carry out forging formation and carry out polish of the whole front face, and cutting-edge attachment to a predetermined configuration after that, surface finish is performed by setting the scissors bodies A and B to the milling machine equipped with especially the end mill tool C, and cutting a front face by this tool C.

[0010] Therefore, even if it misses and a crevice 5 forms in what kind of location in what kind of configuration, the surface finish can be performed by machining processing.

[0011]

[Effect of the Invention] Without hairdressing scissors' missing, and finish-machining a crevice, missing by end mill processing as above, and a configuration being limited to the location list of a crevice by the specific configuration, this invention can perform precision finishing by the machine processing by the milling cutter machine equipped with the end mill tool, and realizes the increase in efficiency of hairdressing scissors fabrication operation.

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DESCRIPTION OF DRAWINGS

[Brief Description of the Drawings]
[Drawing 1] The decomposition perspective view of the hairdressing scissors of the example of an object of the operation gestalt of this invention approach
[Drawing 2] This top view
[Drawing 3] This ** carries out and it is the processing explanatory view of a crevice.
[Description of Notations]
1 Pivotable-Combination Shaft
2 ****
3 Finger Hole
4 Packing
5 Miss and it is Crevice.

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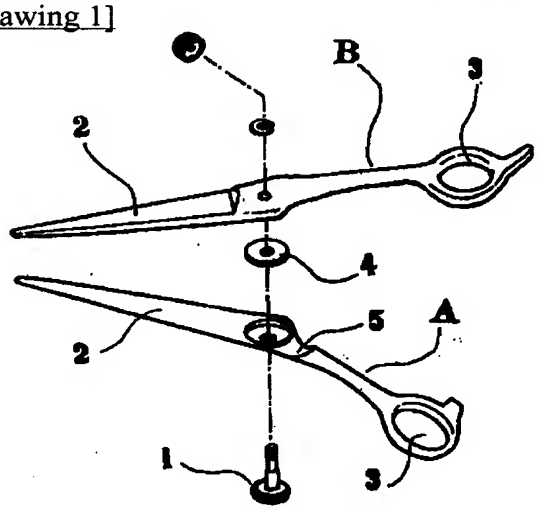
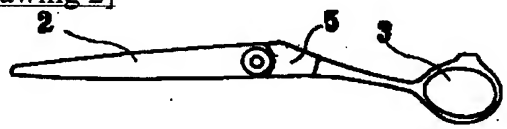
DRAWINGS

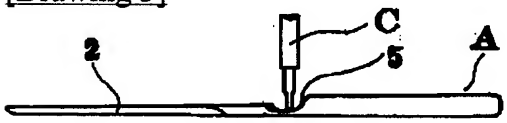
[Drawing 1]



[Drawing 2]



[Drawing 3]



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